

arabic, acacia, carrageenan, xanthan, cellulose, carboxymethylcellulose, hydroxypropylmethocellulose, or mixtures thereof.

21. A filled waffle as recited in claim 11, wherein said starch comprises at least one of natural starch, modified starch, cornstarch, waxy cornstarch, rice starch, wheat starch, tapioca starch, potato starch, arrowroot starch, maize starch, oat starch, or mixtures thereof.

22. A filled waffle as recited in claim 11, wherein said preservative comprises at least one of sodium benzoate, potassium sorbate, sodium propionate, calcium propionate or mixtures thereof.

23. A filled waffle as recited in claim 11, wherein said color and said flavor agents comprise at least one of a natural coloring agent, an artificial coloring agent, a natural flavoring agent, an artificial flavoring agent, or mixtures thereof.

24. A filled waffle as recited in claim 1, wherein said outer casing material further comprises from 40 to 45 percent by weight water, from 35 to 40 percent by weight hard wheat flour, from 6 to 15 percent by weight shortening, from 3 to 7 percent by weight liquid whole egg, from 0.5 to 3 percent by weight whey, from 1 to 5 percent by weight sugar, from 0.5 to 1 percent by weight baking soda, from 0.4 to 0.7 percent by weight sodium aluminum phosphate, from 0.25 to 1 percent by weight salt, and from 0.1 to 0.5 percent by weight monocalcium phosphate.

25. A filled waffle as recited in claim 1, wherein said filling material further comprises a first filling material and a second filling material, said second filling material being other than said first filling material;

each of said first filling material and said second filling material having a positive water content of up to 40 percent by weight and said water content in said first and said second filling material being less than said percent by weight water in said outer casing material; and

said outer casing material having a water activity level of from 0.9 to 0.99 and each of said first and said second filling material having a water activity level of less than or equal to 0.95 with said water activity level of said first and said second filling material being less than said water activity level of said outer casing material.

26. A baked freezer stable filled waffle comprising:

an outer casing material formed from a batter comprising a homogeneous mixture of from 30 to 65 percent by weight water, from 25 to 70 percent by weight flour, from 0.05 to 2.5 percent by weight bicarbonate and from 0.04 to 2 percent by weight leavening acid;

said outer casing material surrounding a filling material formed from a mixture comprising a positive water content of up to 40 percent by weight, from 35 to 80 percent by weight sweeteners, and from 0.5 to 50 percent by weight fruit source;

said water content in said filling material being less than said percent by weight water in said outer casing material; and

wherein said outer casing material has a water activity level of from 0.9 to 0.99 and said filling material has a water activity level of less than or equal to 0.95 with said water activity level of said filling material being less than said water activity level of said outer casing material.

27. A filled waffle as recited in claim 26, wherein said filling material has a water activity level of from 0.7 to 0.95.

28. A filled waffle as recited in claim 26, wherein said filling material has a water activity level of from 0.80 to 0.90.

29. A filled waffle as recited in claim 26, wherein said flour of said outer casing material comprises at least one of all-purpose flour, hard wheat flour, soft wheat flour, whole wheat flour, corn flour, oat flour, rice flour, barley flour, or mixtures thereof.

30. A filled waffle as recited in claim 26, wherein said bicarbonate of said outer casing comprises at least one of ammonium bicarbonate, potassium bicarbonate, sodium bicarbonate, or mixtures thereof.

31. A filled waffle as recited in claim 26, wherein said leavening acid of said outer casing comprises at least one of fumaric acid, adipic acid, acetic acid, tartaric acid, monocalcium phosphate monohydrate, anhydrous monocalcium phosphate, anhydrous dicalcium phosphate, dicalcium phosphate dihydrate, sodium acid pyrophosphate, sodium aluminum phosphate, monoaluminum phosphate, dialuminum phosphate, monoammonium phosphate, diammonium phosphate, sodium aluminum sulfate, or mixtures thereof.

32. A filled waffle as recited in claim 26, wherein said outer casing material further includes at least one of an egg, a fat, a milk product, a sweetener, a salt, a fortificant, a coloring agent, a protein, an emulsifier, a gum, a starch, a flavoring agent, an antimicrobial preservative, or mixture thereof.

33. A filled waffle as recited in claim 26, wherein said filling material further includes at least one of a starch, a fat, a flavor agent, an emulsifier, an acidulant, a hydrocolloid gum, a salt, a coloring agent, an antimicrobial preservative, a humectant, a fortificant, a protein or mixtures thereof.

34. A filled waffle as recited in claim 26, wherein said sweetener of said filling material comprises at least one of sucrose, dextrose, fructose, lactose, malt syrup, malt syrup solids, rice syrup solids, rice syrup, invert sugar, refiners syrup, corn syrup, corn syrup solids, maltose, high fructose corn syrup, honey, molasses, artificial sweeteners, or mixtures thereof.

35. A filled waffle as recited in claim 26, wherein said fruit source of said filling material comprises at least one of fruit flakes, dry fruit flakes, fruit puree, puree concentrate, juice, juice concentrate, fresh fruit, frozen fruit, fruit concentrate, or mixtures thereof.

36. A filled waffle as recited in claim 33, wherein said starch of said filling material comprises at least one of natural starch, modified starch, cornstarch, waxy cornstarch, rice starch, wheat starch, tapioca starch, potato starch, arrowroot starch, maize starch, oat starch, or mixtures thereof.

37. A filled waffle as recited in claim 33, wherein said fat of said filling material comprises at least one of non-hydrogenated vegetable oil, non-hydrogenated shortening, partially hydrogenated vegetable oil, partially hydrogenated shortening, fully hydrogenated vegetable oil, fully hydrogenated shortening, soybean oil, cottonseed oil, canola oil, peanut oil, safflower oil, sunflower oil, coconut oil, palm oil, palm kernel oil, olive oil, butterfat oil, cocoa butter oil, tallow, lard, corn oil, or mixtures thereof.

38. A filled waffle as recited in claim 33, wherein said flavor agent comprises at least one of a natural flavor, an artificial flavor, or mixtures thereof.